

Monday, 12/10/2007 12:00:49 PM

User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE SHAFT
Job Number	: 36218		
Estimate Number	: 12187		
P.O. Number	: <i>NIA</i>	Part Number	: D34695.
This Issue	: 12/10/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D3469' REV.A1
First Issue	: <i>MA</i>	Project Number	: N/A
Previous Run	: 34409	Drawing Revision	: A1
		Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/24/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	5 Um: Each
Comment	: est rev A 06.02.06 new issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2857 sf(s)/Unit Total: 1.4285 sf(s)
 304/316 0.018 SHEET
 (M304S26GA)
 Batch: *105592* *IB 07-12-11*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 Cut as per Dwg D3469
 Dwg Rev: *A1*
 Prog Rev: *A1*

*IB 07-12-11**(8)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-12-11

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 07/12/11 *(10005)* *(18)*

5.0 NAS1031C3W Nutplate



Comment: Qty.: 17.0000 Each(s)/Unit Total: ~~85.0000~~ Each(s) *136*
 pick:

Qty	Part number	Description	Batch
17	NAS1031C3W	Nutplate	<i>M106101(x89)</i>

(M106574 X47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FE Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/10/2007 12:00:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 36218

Part Number: D34695

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary ✓

2-form oval flanges per dwg D3469 using DT8850 ✓

3-Spot weld nut plates as per dwg D3469 ✓

X8

ml 08/01/09

7.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 08/01/15 (8)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/10/15 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 163

AS 08/01/15 (X8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/16

Job Completion



U 08-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

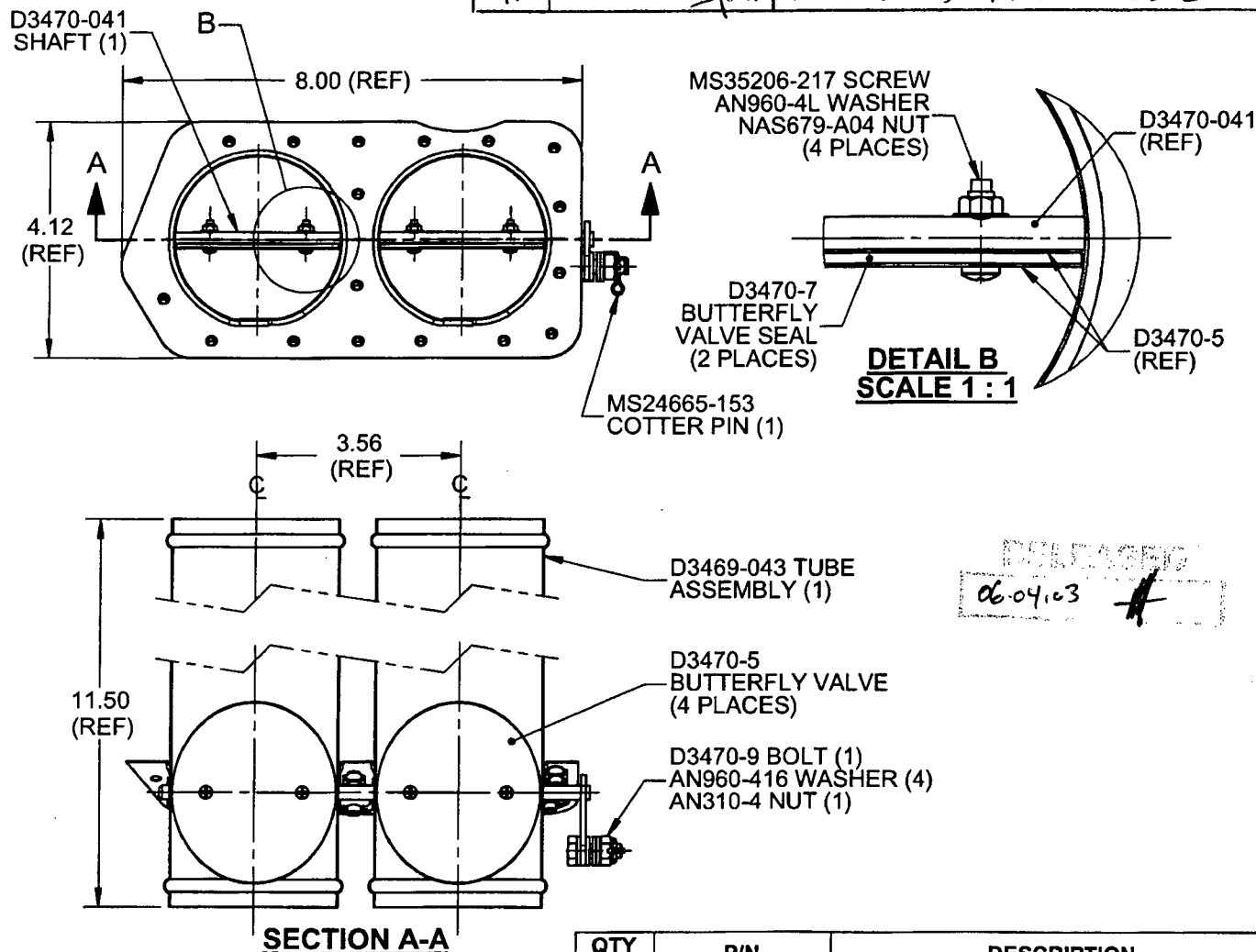
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED B.O.M. ON PAGE 2	



D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

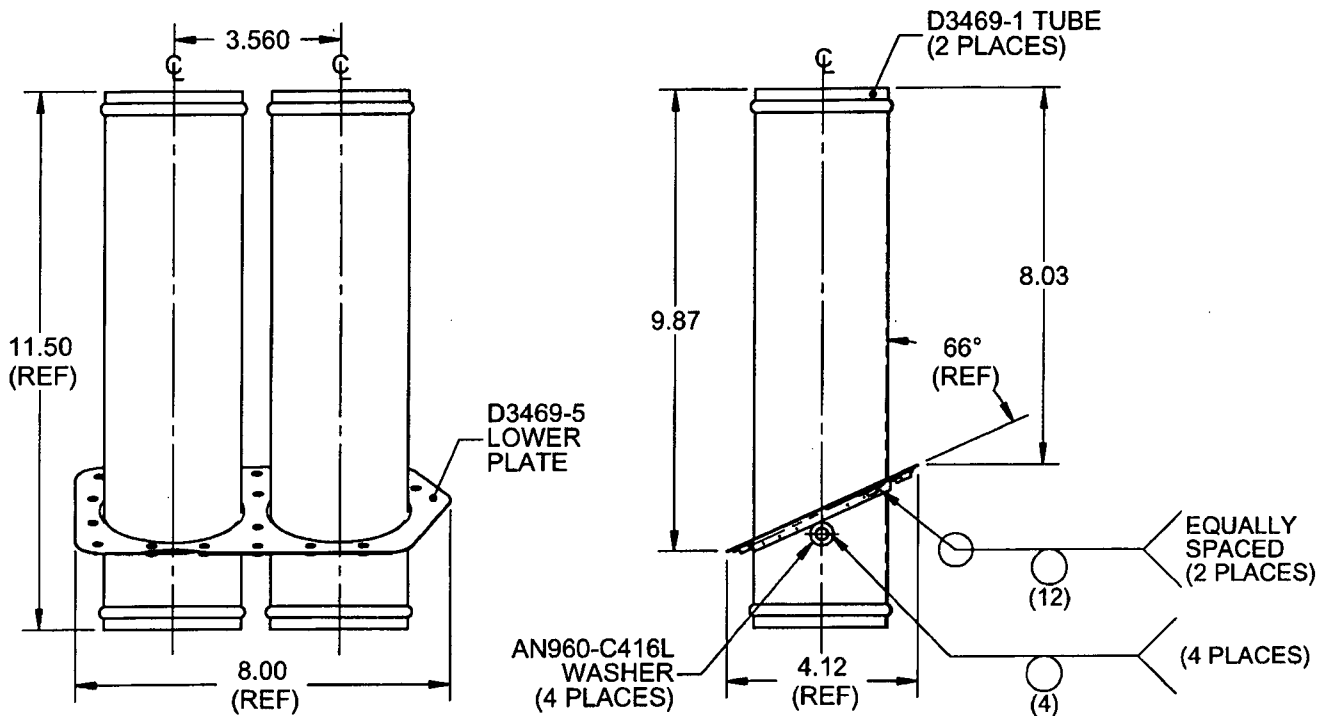
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CHECKED #	APPROVED #	DRAWING NO. D3469	REV. A SHEET 2 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

RELEASED
06-04-03



D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE
4	AN960-C416L	WASHER

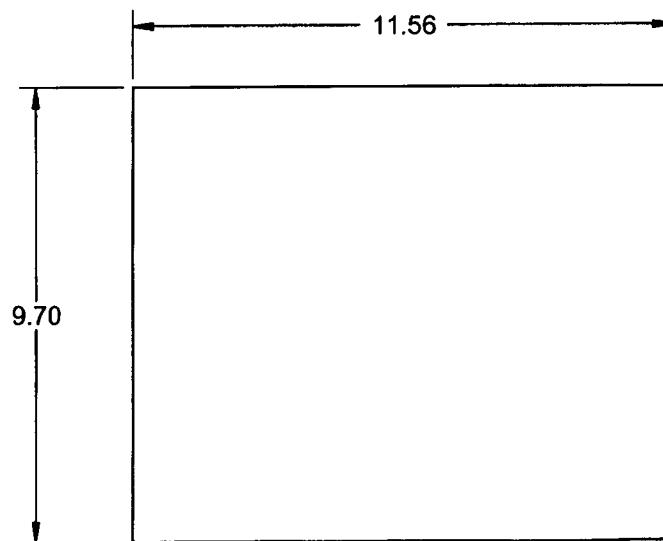
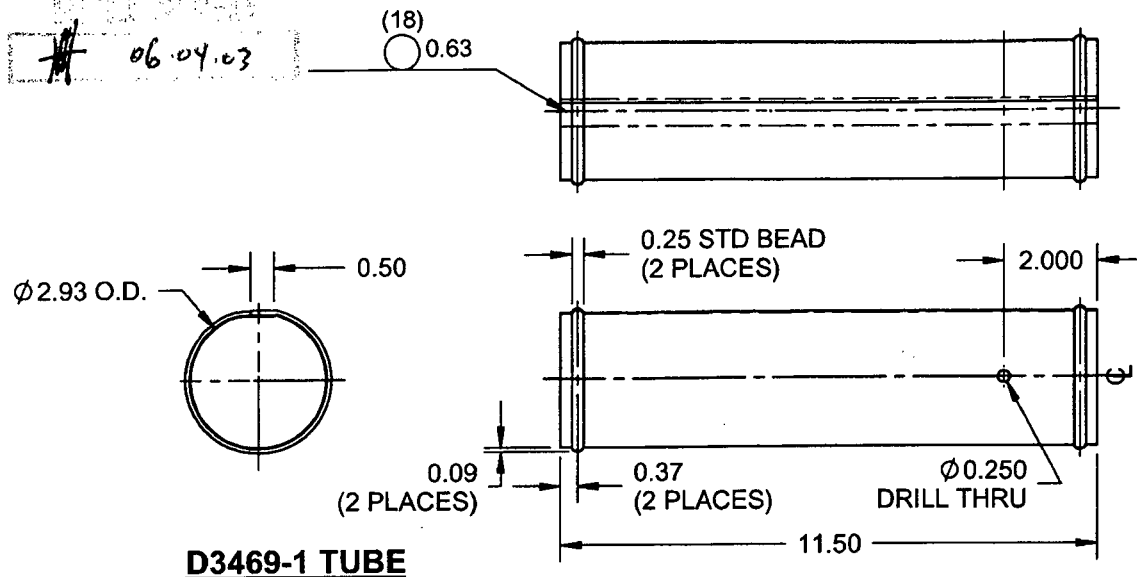
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

**D3469-1F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

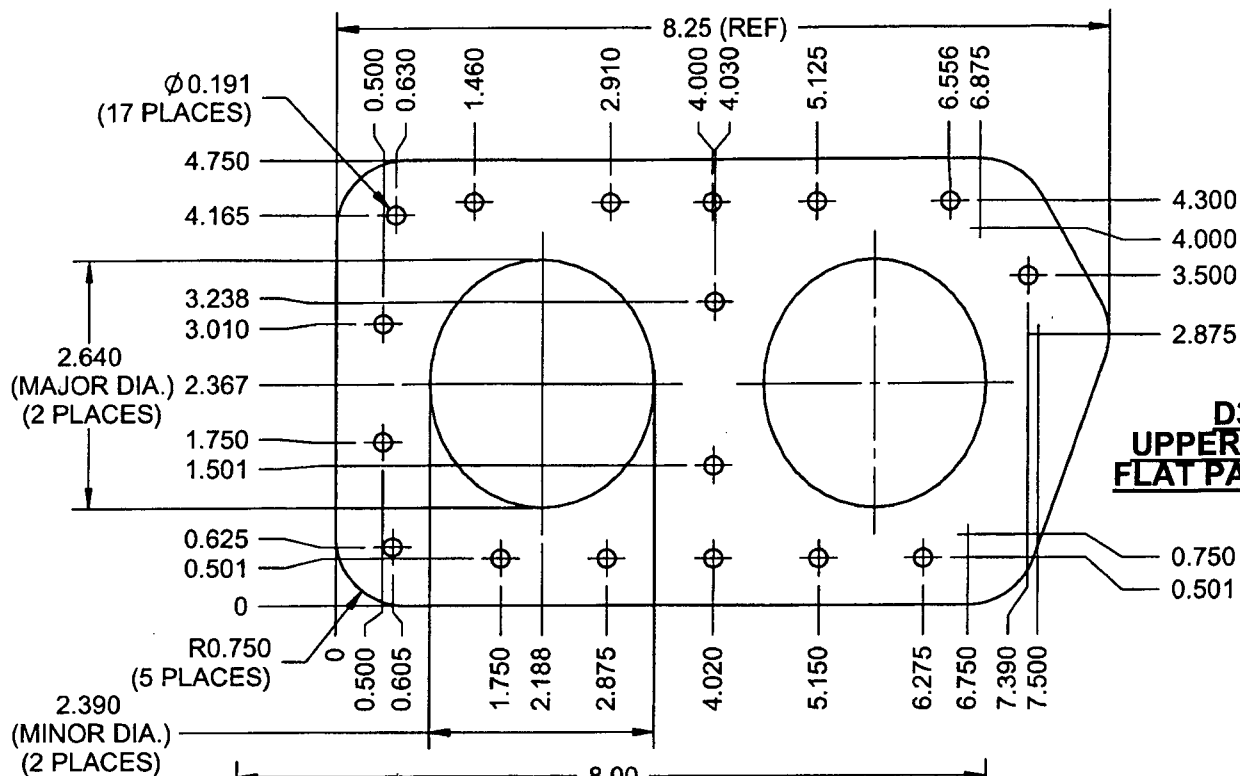
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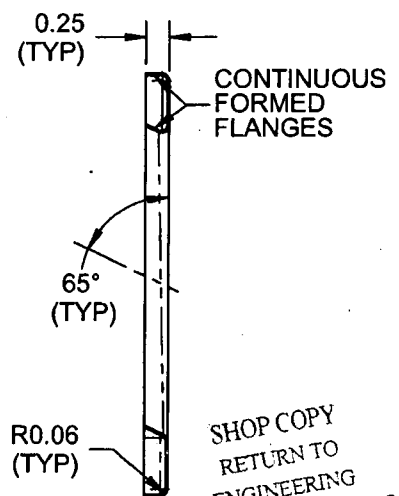
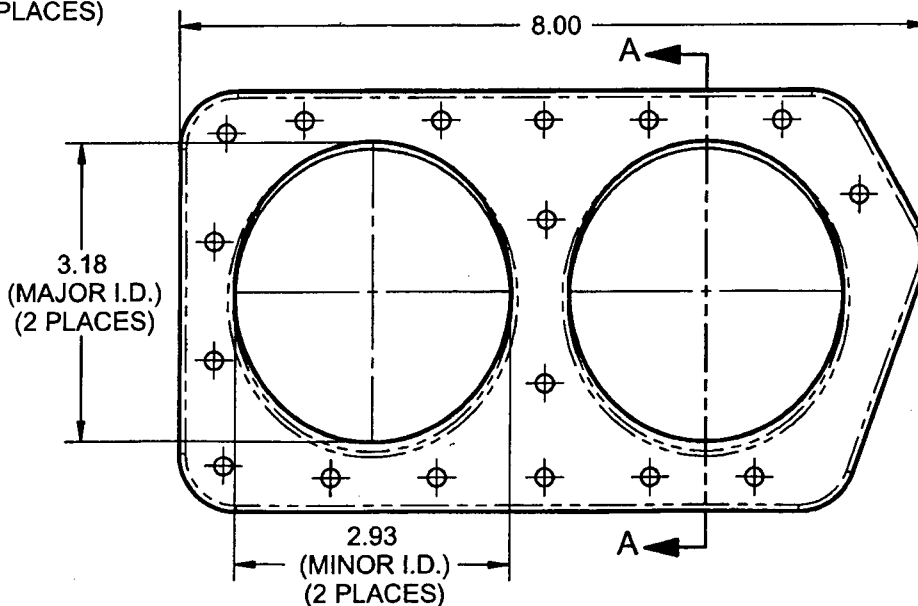
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



**D3469-3F
UPPER PLATE
FLAT PATTERN**



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NO. **36218**

D3469-3 UPPER PLATE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

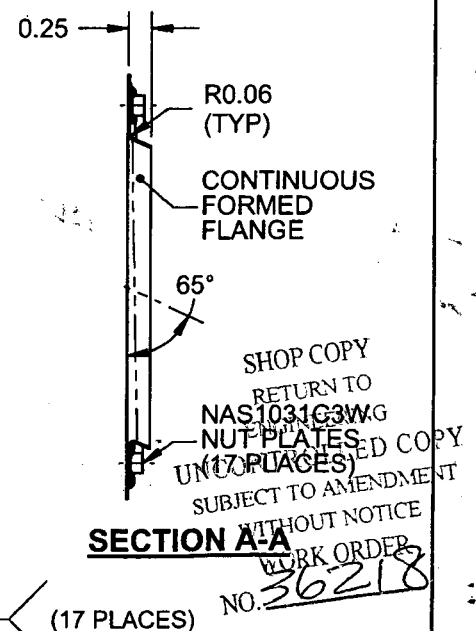
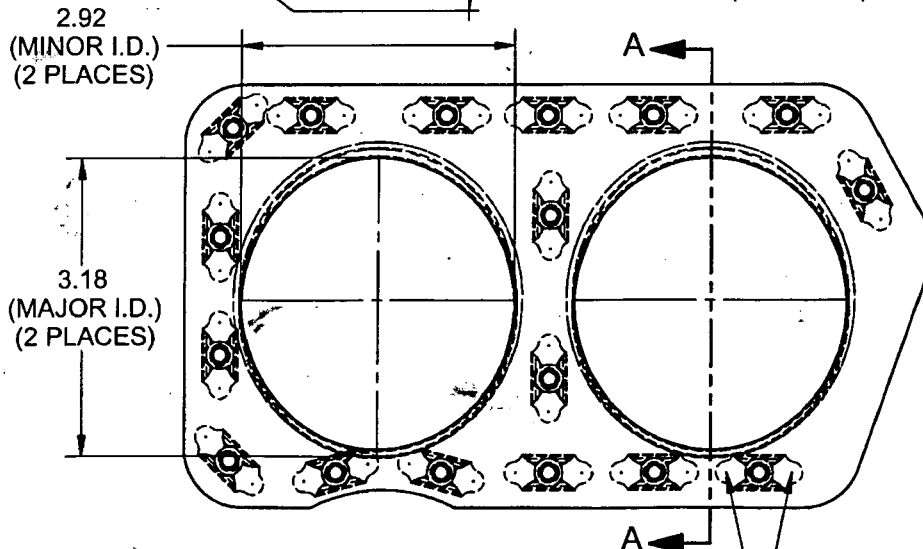
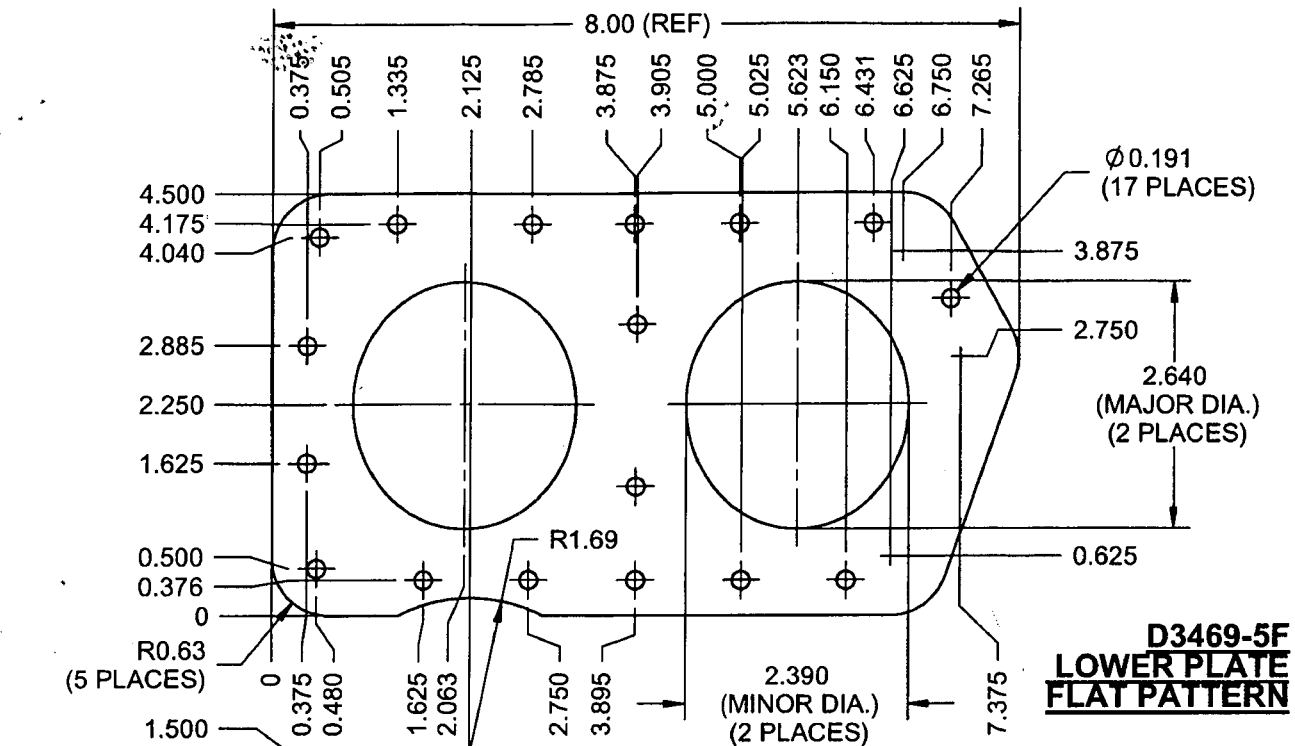
06-07-03

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DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2

**D3469-5 LOWER PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 51

EMPLOYEE: Monique Lepege

PART NUMBER: D3469-5

JOB NUMBER: B36218

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SJ

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 08/01/09
QUALIFIER: SJB